

Date: Friday, 5/25/2007 8:15:54 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT GUSSET (350) BASKET		
Job Number	: 32571					
Estimate Number	: 10496					
P.O. Number	: N/A		Part Number	: D2325		
This Issue	: 5/25/2007	S.O. No. : N/A	Drawing Number	: D2325 REV B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 31423		Material	: N/A		
Written By			Due Date	: 6/20/2007 Qty: 100 Um: Each		
Checked & Approved By						
Comment	: Est. D 02.12.06 Reformat; Rev B KJ/RF Est. E 06.05.03 Water jet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet X <i>m101873 x6 29.298</i>
		Comment: Qty.: 0.4883 sf(s)/Unit Total : 48.8250 sf(s) 304/316 SS .063 Sheet Batch: m103961 <i>x40 19.532</i> <i>ml 01 06 09</i> (100)
2.0	WATER JET	FLOW WATER JET <i>ml 01 06 09</i> (100)
		Comment: FLOW WATER JET 1-Cut as per Dwg D2325 Dwg Rev: B <i>ml 01 06 09</i> (100) Prog Rev: B
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 01 06 09</i> (100)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>J0706.12</i> (100) <i>counted</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>ml 01 06 09</i> (100)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>SAO 07/07/04</i> (100) <i>99</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT GUSSET (350) BASKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Scanned

Comment: INSPECT WORK TO CURRENT STEP

En route

499

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: WS

7/7/06 (99)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



92

Comment: FINAL INSPECTION/W/O RELEASE

7/7/06

Job Completion



d 8/7/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief.Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32571
Description: Support Gusset	Part Number:	D2325
Inspection Dwg: D2325 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	ml, ml
Date:	07 08 09

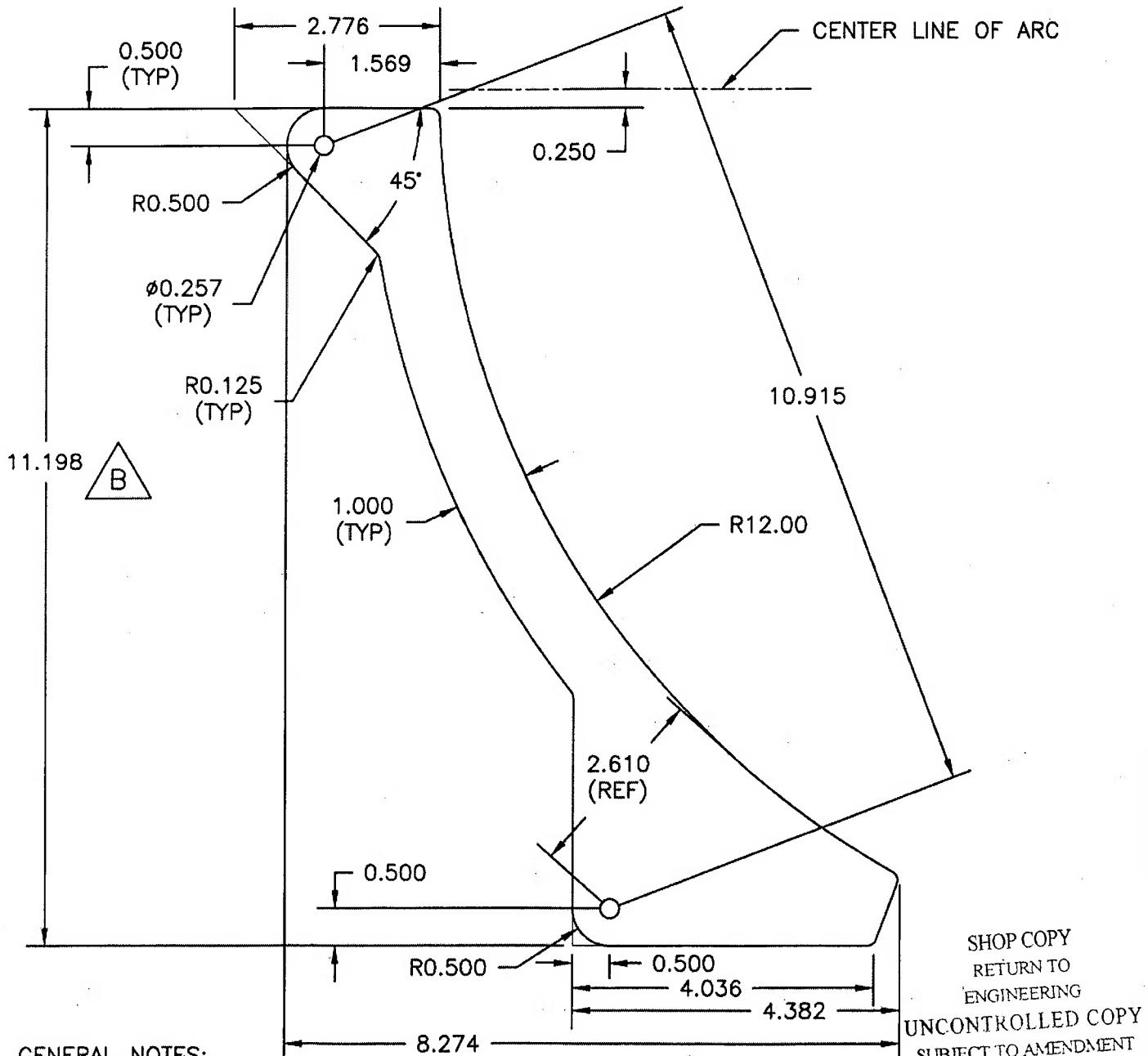
Audited by:	<i>J</i>
Date:	<i>07-06-12</i>

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.08	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2325	SHEET 1 OF 1
DATE		TITLE	SCALE
02.08.28		SUPPORT GUSSET	1:2
A	94.12.13	NEW ISSUE	
B	02.08.28	REFORMAT; 11.198 WAS 11.948	

RELEASED
02.08.29 #
**GENERAL NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16CA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32571

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